

Work Order ID 80343

February-17-12 8:33:46 AM

80343

Page 1

Item ID: D3564-5 Accept ***N900040-100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 17/02/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 12/02/12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3564	Rev.D

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-								
304, 063	Deburr if necessary								

12.03.01 (12)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

12.03.02 (12)

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

5/7/03/02 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

February-17-12 8:33:46 AM

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 Revision ID: Stop ***NS2***
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 Start Date: 17/02/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	4	11	12/03/12
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>FPI</u> Memo	0.00 0.00				12	2	12/03/12	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/3/13

12-03-12

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NOTE: Date & initial all entries

Picklist Print

February-17-12 8:34:04 AM

Page 1

Work Order ID: 80343

80343

Parent Item: D3564-5

D3564-5

Parent Item Name: Wearshoe

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	58.0000	1.5	18.94737			
**													
w/ 12.03.01													

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	58	
119653	58	
120866		

18.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80343
Description: Wearshoe		Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	✓		M.T	HB-01
6.75	+/-0.030	6.75	✓		M.T	
10.00	+/-0.030	10.00	✓		M.T	
20.00	+/-0.030	20.00	✓		M.T	
30.00	+/-0.030	30.00	✓		M.T	
2.50	+/-0.030	2.50	✓		M.T	
3.227	+/-0.010	3.226	✓		V.V.N	HB-02
38.500	+/-0.010	38.500	✓		M.T	HB-01
5.500	+/-0.010	5.500	✓		M.T	
2.50	+/-0.030	2.50	✓		M.T	
2.432	+/-0.010	2.437	✓		V.V.N	HB-02
0.300 x 0.300	+/-0.010	304x.304	✓		V.V.N	
Ø0.188	+0.005/-0.001	0.190	✓		V.V.N	
R0.375	+/-0.010	0.375	✓		RG	
0.063	+/-0.010	0.059	✓		V.V.N	

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12.03.02	Date:	12/03/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	<i>[Signature]</i>

Dart Aerospace Ltd

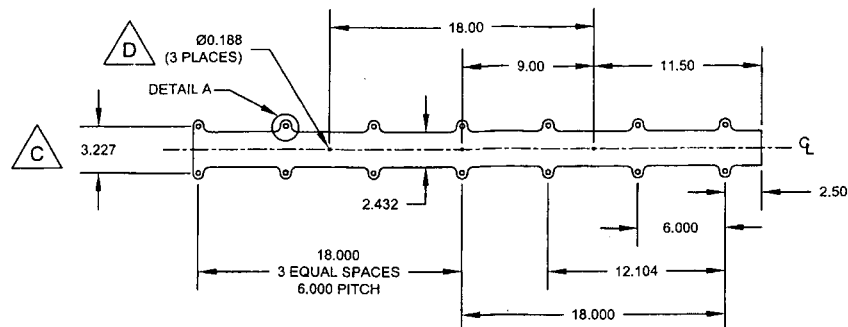
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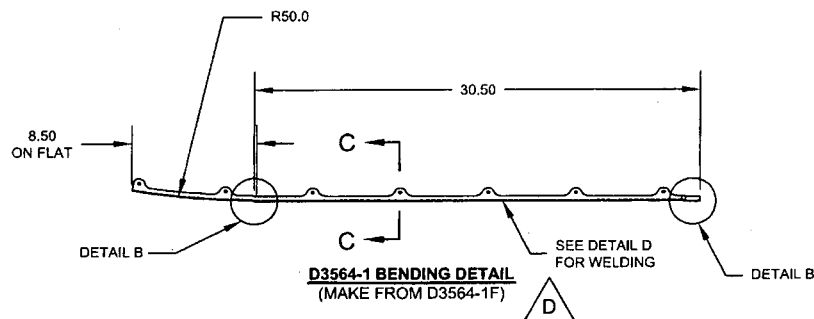
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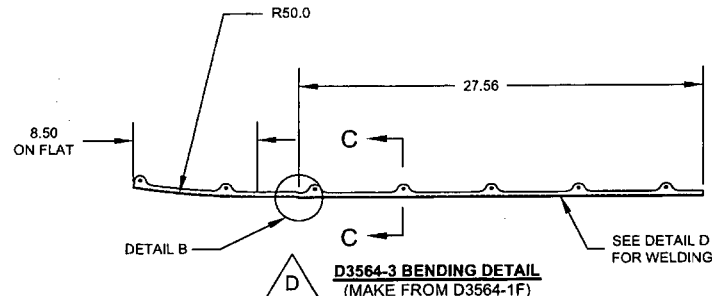
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY
RETURNED
UNCONTROLLED COPY
SUBJECT TO CHANGE
NO. 80343 M.C.J
12/02/17

RELEASED

07.09.04

UNDER REVIEW
First change
OK 11.11.18

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D
D3564 SHEET 1 OF 3
TITLE SCALE
WEARSHOE 1:8

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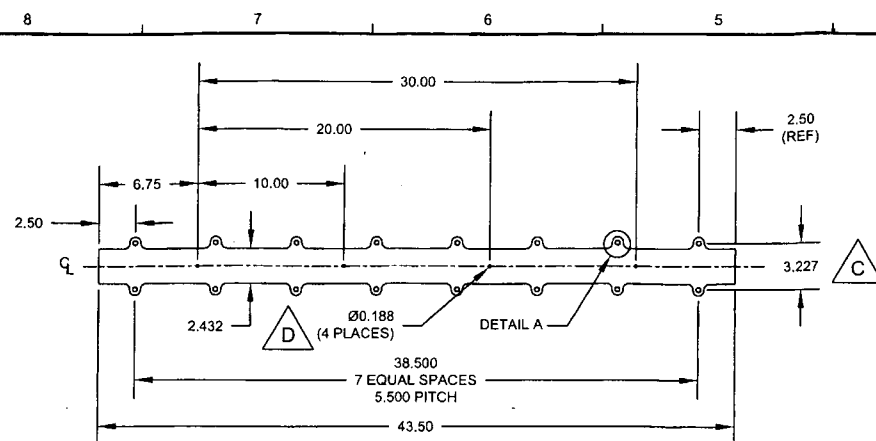
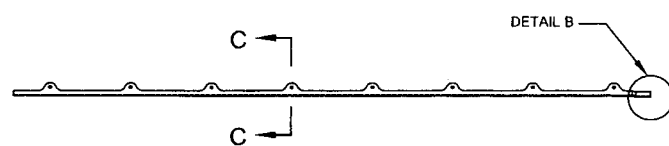
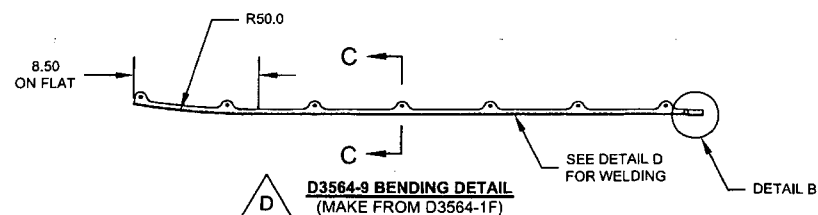
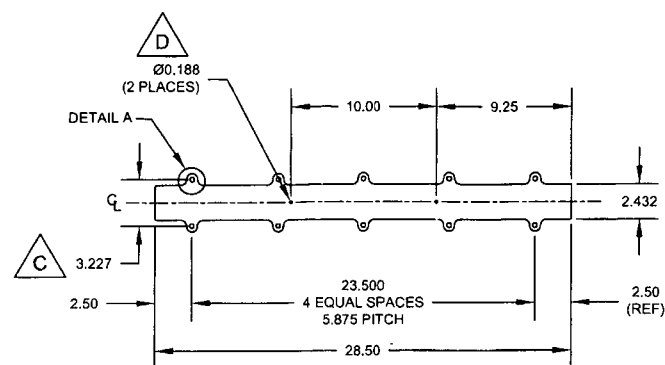
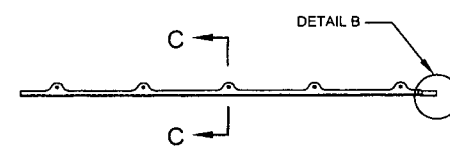
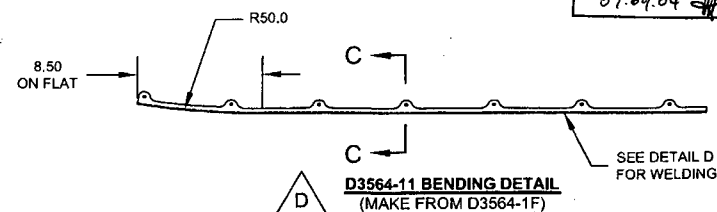
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**D3564-5F FLAT PATTERN****D3564-5 BENDING DETAIL**
(MAKE D3564-5 FROM D3564-5F)**D3564-9 BENDING DETAIL**
(MAKE FROM D3564-1F)**D3564-7F FLAT PATTERN****D3564-7 BENDING DETAIL**
(MAKE D3564-7 FROM D3564-7F)**D3564-11 BENDING DETAIL**
(MAKE FROM D3564-1F)

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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UNDER REVIEW

OK CP 11.11.28

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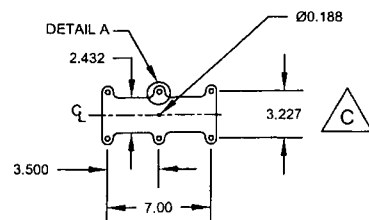
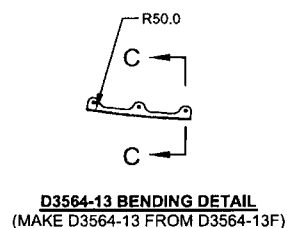
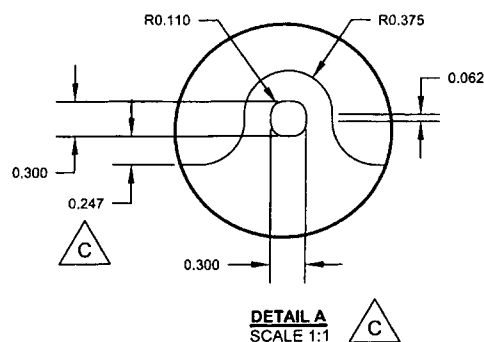
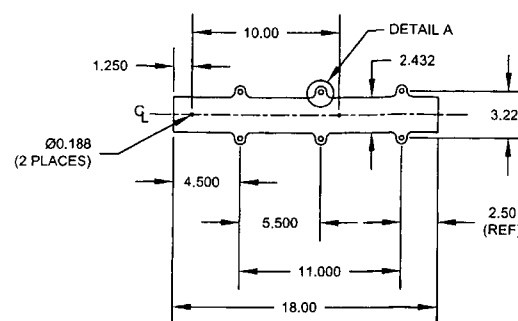
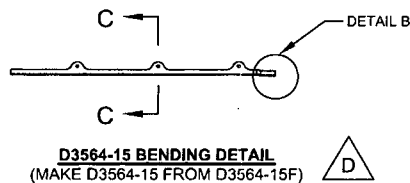
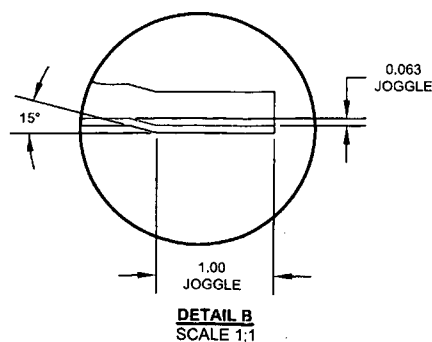
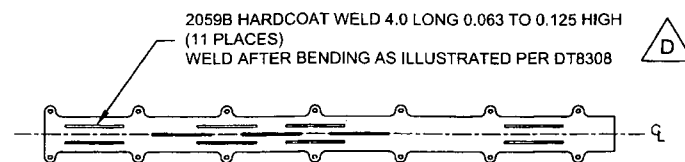
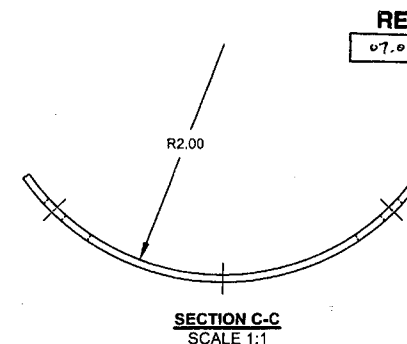
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**D3564-13F FLAT PATTERN****D3564-13 BENDING DETAIL**
(MAKE D3564-13 FROM D3564-13F)**DETAIL A**
SCALE 1:1**D3564-15F FLAT PATTERN****D3564-15 BENDING DETAIL**
(MAKE D3564-15 FROM D3564-15F)**DETAIL B**
SCALE 1:1**DETAIL D**
(D3564-1/-3/-9/-11 WELDING DETAIL)**SECTION C-C**
SCALE 1:1RELEASED
07.09.04UNDER REVIEW
OK 07.11.28

DESIGN	AY	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AY	DRAWING NO.	REV. D
MFG. APPR.	AY	D3564	SHEET 3 OF 3
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